

Work Order ID 79235-3

January-24-12 9:56:39 AM

79235

Page 1

Item ID: D3414-041

Revision ID:

Item Name: Lug Assembly

Start Date: 24/01/2012 Start Qty: 40.00

Required Date: 10/02/2012 Req'd Qty: 40.00

Reference:

Accept

N9000040100

Setup Start *NS1*

Stop *NS2*

Cust Item ID:

Customer:

Approvals: Process Plan: M.L.S

Date: 12/01/24 Tooling:

Date:

Run Start *NR1*

QC:

Date: SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan
Code Accept Reject
Qty Qty Number Insp.
Stamp

Draw Nbr

Revision Nbr

D3414

Rev C

100

0.00

100

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3414-1

Dwg Rev: C

Prog Rev: 1

2-Debur if necessary

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

Quality Control

spat

40
40

12-1-24

(44)

12-1-24

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Item ID: D3414-041

Accept

N900040100

Setup Start *NS1*

Revision ID:

Item Name: Lug Assembly

Stop *NS2*

Start Date: 24/01/2012 Start Qty: 40.00

40

Required Date: 10/02/2012 Req'd Qty: 40.00

40

Cust Item ID:

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.00

Quality Control

130

0.00

130

Brake NC

Memo

0.00

Brake NC

1-Debur

2-Form using DT8254 as per Dwg D3414

140

0.00

140

Large Fab

Memo

0.00

Large Fab

1- Weld using location fig DT9625 as per Dwg D3414

A/R S.S. welding rod Batch: ~~116517~~

m120013

EL 12-4-23

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Item ID: D3414-041

Revision ID:

Item Name: Lug Assembly

Start Date: 24/01/2012 Start Qty: 40.00

Required Date: 10/02/2012 Req'd Qty: 40.00

Reference:

Accept

N900040100

Setup Start ***NS1***

Stop ***NS2***

Cust Item ID:

Customer:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
---------	--------	-----------	------------	------------	---------------	-------------

150

QC9- Inspect visual per QSI004- Fusion Welds

0.00

150

QC

Memo

0.00

Quality Control

Handwritten: 12-04-24

160

QC5- Inspect part completeness to step on W/O

0.00

160

QC

Memo

0.00

Quality Control

Handwritten: Srd 12/25

Handwritten: (+40)

175

0.00

175

SprayPaint

Memo

0.00

Spray Painting

PRIME B 117319
DEL FLEET BLUE B 121149
CLEAR DEL FLEET B 118093

Handwritten: AS 12-5-1 (4)

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Item ID: D3414-041

Revision ID:

Item Name: Lug Assembly

Start Date: 24/01/2012 Start Qty: 40.00

Required Date: 10/02/2012 Req'd Qty: 40.00

Reference:

Accept

N900040100

Setup Start ***NS1***

Stop ***NS2***

Cust Item ID:

Customer:

Approvals: Process Plan:

QC:

Date:

Date:

Tooling:

SPC (Y/N):

Date:

Date:

Run Start ***NR1***

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan Code Accept Qty Reject Qty Reject Number Insp. Stamp

185

QC14- Inspect Spray Paint

0.00

185

QC

Memo

0.00

Quality Control

12.05.03 (4)

190

Identify as per dwg & Stock Location: 420

0.00

190

Packaging

Memo

0.00

Packaging

(4) 12/5/8

200

QC21- Final Inspection - Work Order Release

0.00

200

QC

Memo

0.00

Quality Control

12/5/8 12/5/7

Picklist Print

January-24-12 9:56:42 AM

Page 1

Work Order ID: 79235

Parent Item: D3414-041

Parent Item Name: Lug Assembly

79235

D3414-041

Start Date: 24/01/2012

Required Date: 10/02/2012

Start Qty: 40.00

Required Qty: 40.00

Comments: IPP A05.09.13 New issue KJ/JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S12GA		Purchased	No			100	sf	131.3300	0.155	6.2			
**													
B 17-1-2%													
M304S12GA													
304/316 0.100" Sheet													

Location	Loc Qty	Loc Code
MAT019	131.33	
113062	117.1	
113077	14.23	

D3414-3

D3414-3

Lug

Manufactured No

140 Each 0.0000 1 40

**

76228 X 4 EL. 12-4-23

B 78923 →

D3414-3

B 78923

DART AEROSPACE LTD		Work Order:	79735
Description: Lug Bracket		Part Number:	D3414-1
Inspection Dwg: D3414	Rev: C	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

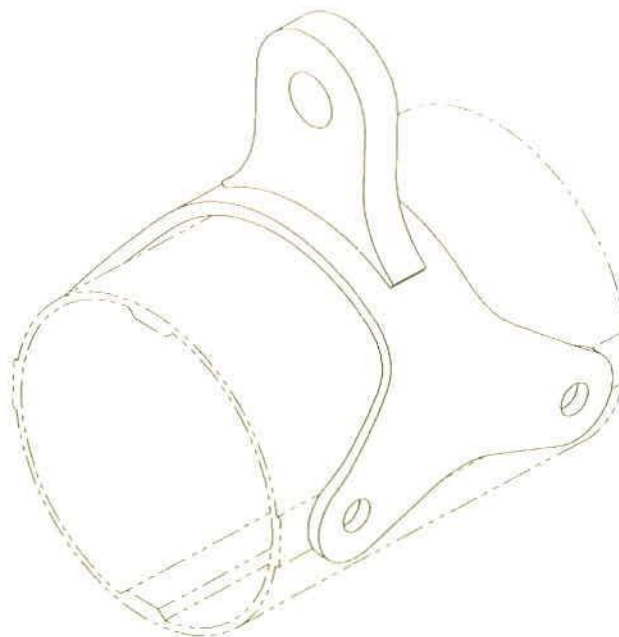
☒ First Article ☒ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.313	+0.006/-0.001	0.313	✓			
1.19	+/-0.030	1.19	✓			
1.00	+/-0.030	1.009	✓			
3.38	+/-0.030	3.385	✓			
5.350	+/-0.010	5.348	✓			
6.23	+/-0.030	6.230	✓			
2.500	+/-0.010	2.500	✓			
0.37	+/-0.030	0.37	✓			
0.100	+/-0.010	0.100	✓			

Measured by: R	Audited by: J	Prototype Approval:	N/A
Date: 10-1-06	Date: 10-1-06	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	08.02.28	New Issue P/O D3414-041	KJ/DD	
B	09.05.27	Dimensions updated per Dwg Rev B	KJ	
C	09.10.16	Dwg Rev updated to Rev C	KJ	

ITEM No.	QTY. -041	PART NUMBER	DESCRIPTION
1	X	D3414-041	LUG ASSEMBLY
2	1	D3414-1	LUG BRACKET
3	1	D3414-3	LUG



D3414-041 LUG ASSEMBLY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3414-041" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.52 lbs

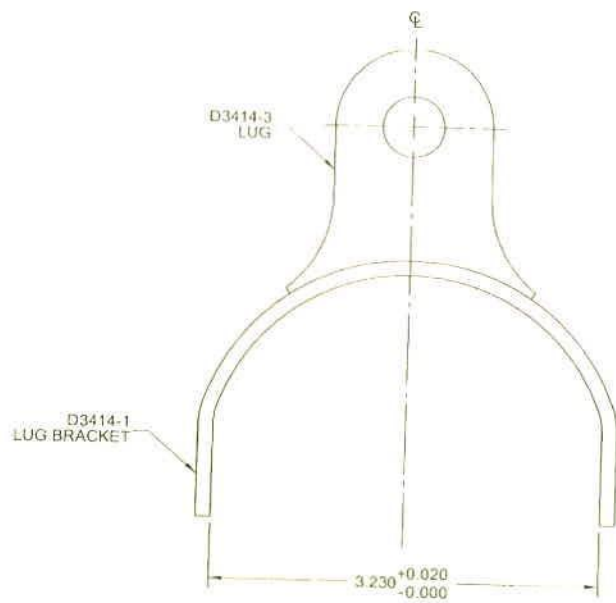
79235 H.C.S.
12/01/24

RELEASED
3/16/2024

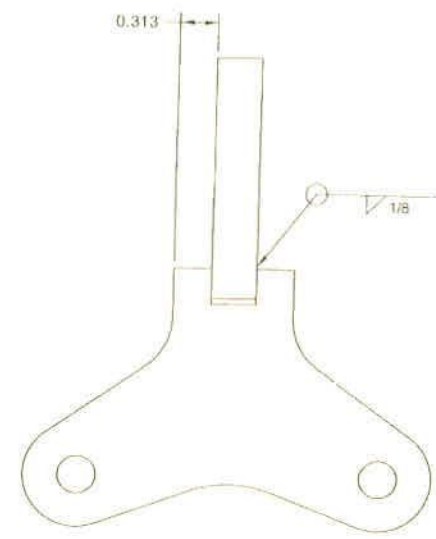
C	BREAK SHARP EDGES FOR -3 NOW 0.030-0.060 WAS 0.010-0.030 (ZN A7-3)	CP	09.06.17
B	DRAWING REDRAWN IN SOLIDWORKS WITH CURRENT STANDARDS AND TRANSFERRED TO "B" SIZE BORDER. FLAT PATTERN FOR -1 INCREASED IN LENGTH TO PREVENT FOULING AT INSTL (SEE PAR198). FLAT SPOTS REMOVED FROM -1 (PART NOW "U" SHAPED) FOR EASE OF MANUFACTURE. B7-3 ADDED TOLERANCE TO 3.230. DIM C2-3 1 12 DIM WAS 1.20.	AJS	08.09.23
A	NEW ISSUE	CP	05.03.16
REV.	DESCRIPTION	BY	DATE
DESIGN	CP		
DRAWN	CP		
CHECKED	CP		
MFG. APPR.	CP		
APPROVED	CP		
DE APPR.	CP		
DATE	09.06.17		

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. D3414	REV. C SHEET 1 OF 3
TITLE LUG ASSEMBLY	SCALE NTS
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79235



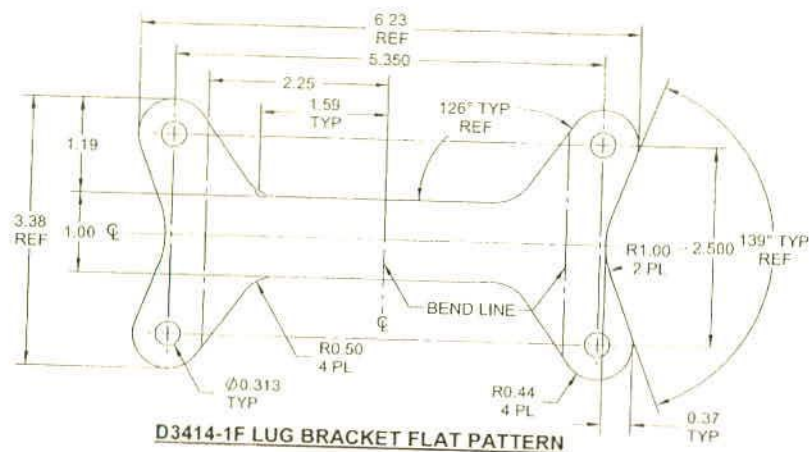
D3414-041 LUG ASSEMBLY



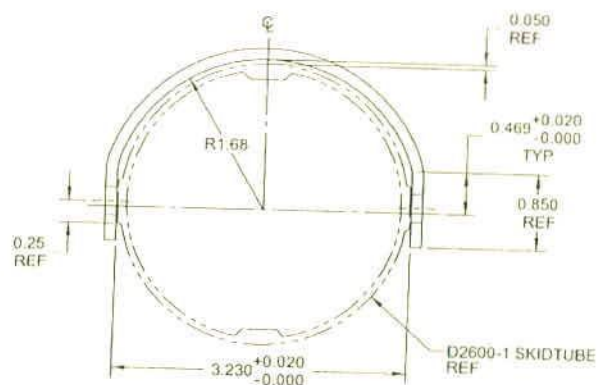
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DESIGN	CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	CP		
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3414	SHEET 2 OF 3
APPROVED		TITLE	SCALE
DE APPR.		LUG ASSEMBLY	NTS
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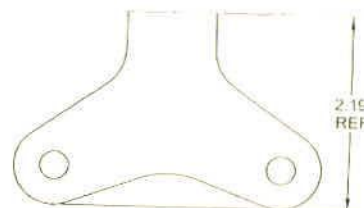
79235



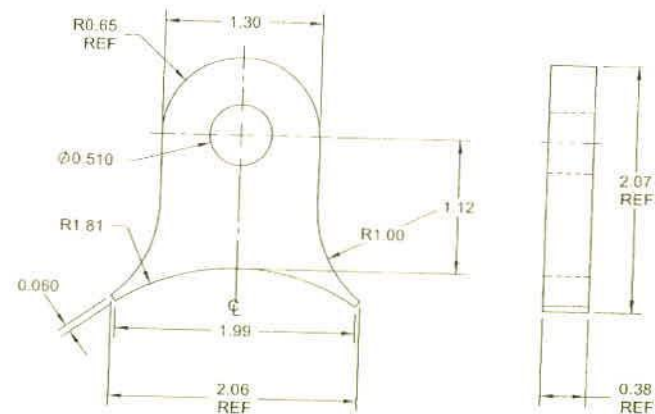
D3414-1F LUG BRACKET FLAT PATTERN



D3414-1 LUG BRACKET



SIDE VIEW FOR REF ONLY



D3414-3 LUG

NOTES

1) MATERIAL: -1 AISI 304/316 STAINLESS STEEL SHEET, 12 GAUGE (0.100 THICK)
PER MIL-S-5059 (ANNEALED) 2B FINISH OR AMS 5513/5524
REF. DART SPEC. M304S12GA

-3 AISI 304/316 STAINLESS STEEL PLATE
PER MIL-S-5059 (ANNEALED) 2B FINISH OR AMS 5513/5524
REF. DART SPEC. M304S

2) FINISH: N/A

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: -1: 0.010 TO 0.020 MAX
-3: 0.030 TO 0.060 MAX

6) IDENTIFICATION: N/A

7) WEIGHT: N/A

RELEASED
09/06/17

DESIGN	CP	DART AEROSPACE LTD	
DRAWN	CP	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3414	SHEET 3 OF 3
APPROVED		TITLE	SCALE
DE APPR.		LUG ASSEMBLY	NTS
DATE	09.06.17	COPYRIGHT © 2005 BY DART AEROSPACE LTD.	